

Amendments to the Specification

Please amend the paragraph starting on page 5, line 24 and ending on page 6, line 2, as follows:

B3

Figure 3 shows a front view of a carrier according to another embodiment of the invention. Welding torches 7a, 7b are connected here to carrier 6 by means of clamping jaws 15a. In addition, there is provided a guide ring 5 which is held at a distance from the pipes and with which guide wheels 8 are in contact. No engaging ring 11 is therefore present. The two welding torches 7a, 7b placed successively in longitudinal direction of weld groove 2, indicated with arrow 23, lay two welding layers A, B in one welding pass. Because the trailing welding torch 7b lays welding layer B over the welding layer A deposited by the leading welding torch 7a, the trailing welding torch 7b is placed higher in its torch holder ~~torch holder~~ clamping jaws 15a than welding torch 7a. Welding torches 7a, 7b are placed radially relative to pipes 1 so that they enclose a mutual angle.

Please amend the paragraph starting on page 6, line 3 and ending on page 6, line 23 as follows:

B4

Using figure 4 and 5 a preferred embodiment of the method according to the present invention will be elucidated. Arrow AA designates the welding movement of the leading welding torch 7a and arrow BB that of the trailing welding torch 7b. Both welding torches perform an oscillating movement, wherein the trailing welding torch 7b is oscillated at a greater amplitude and a higher frequency than the leading welding torch 7a. By means of this method a weld groove 2 is filled which has outward diverging walls. Since weld groove 2 widens towards the outside, the trailing welding

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torch 7b must in each welding pass deposit a wider welding layer than leading welding torch 7a, and is therefore oscillated at a greater amplitude than leading welding torch 7a. In addition, the trailing welding torch 7b is preferably oscillated at a higher frequency than leading welding torch 7a in order to enable filling of the wider weld groove 2 with the same quantity of material. The amplitude and frequency of the oscillation movement of each welding torch 7a, 7b is adapted per welding pass to the width of the weld groove 2 for filling.

Please cancel the Abstract of the Disclosure and substitute therefor the following Abstract of the Disclosure on a separate sheet.